

Date: Monday, 18/08/2008 3:31:42 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MIRROR BRACKET LH		
Job Number	: 41316A01					
Estimate Number	: 10146					
P.O. Number	:		Part Number	: D20131		
This Issue	: 18/08/2008	S.O. No. :	Drawing Number	: D2013 REV C		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type : SMALL /MED FAB	Drawing Revision	: C		
Previous Run	: 36950		Material	:		
Written By	:		Due Date	: 10/09/2008 Qty: 4 Um: Each		
Checked & Approved By	: JLD 08-848					
Comment	: Est Rev:A New Issue 05-11-01 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 2.0447 f(s)/Unit Total: 8.1787 f(s) Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing (M304TR0.750W.049) Batch: M 110 113	
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Punch as per template D2013-T1and Dwg D2013 2-Flatten ends of D2013-1 tube as per Dwg D2013 using DT8545 3-Bend (1) tube as per Dwg D2013 using Jig DT8201Identify as D2013-1. 4-Deburr as required	 SB 09/01/08 FF 09/01/12 M 110 09/01/12 FF 09/01/19 m-h 09/01/12
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	 S 09/01/19 X4
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 241	 SS 09/01/20 X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:31:42 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET LH

Job Number: 41316A01

Part Number: D20131

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 QC21

FINAL INSPECTION/W/O RELEASE



09/01/21 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09.01.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

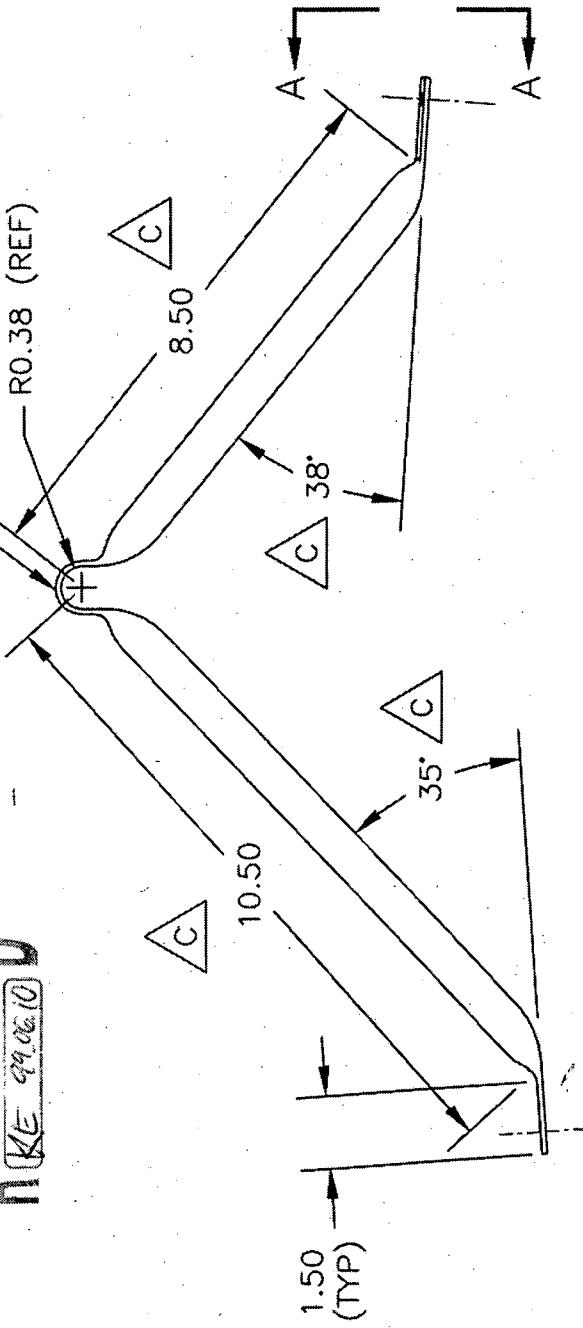
DART



DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RE	APPROVED JS	DRAWING NO. D2013	REV. C SHEET 1 OF 3
DATE 99.06.07		TITLE MIRROR BRACKET	SCALE NTS
A	90.10.22	NEW ISSUE	
B	94.06.15	REDRAWN	
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS	

BEND PER JIG DT8201

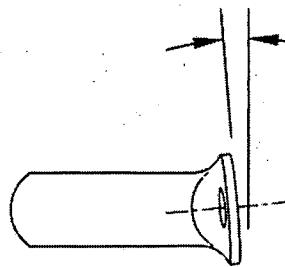
RELEASED
(RE-entire)



-D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)

DRILL Ø0.257 (TYP)
0.400 (TYP)

CUT LENGTH: 23.25 INCHES



VIEW A-A

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 4136101

DART

OR COPY IS
NOT OK

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JF	DRAWING NO. D2013	REV. C SHEET 2 OF 3
DATE 99.06.07		TITLE MIRROR BRACKET	SCALE NTS

BEND PER JIG DT8201

RELEASED
RE KE 14.06.00

R0.38 (REF)

R0.38 (REF)

8.50

8.50

10.50

10.50

32.

32.

1.50 (TYP)

1.50 (TYP)

Copyright 1990 by DART AEROSPACE LTD

D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)

R0.25
(TYP)

R0.25
(TYP)

DRILL Ø0.257 (TYP)

Ø0.257 (TYP)

0.400 (TYP)

0.400 (TYP)

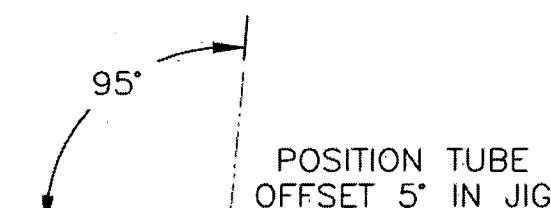
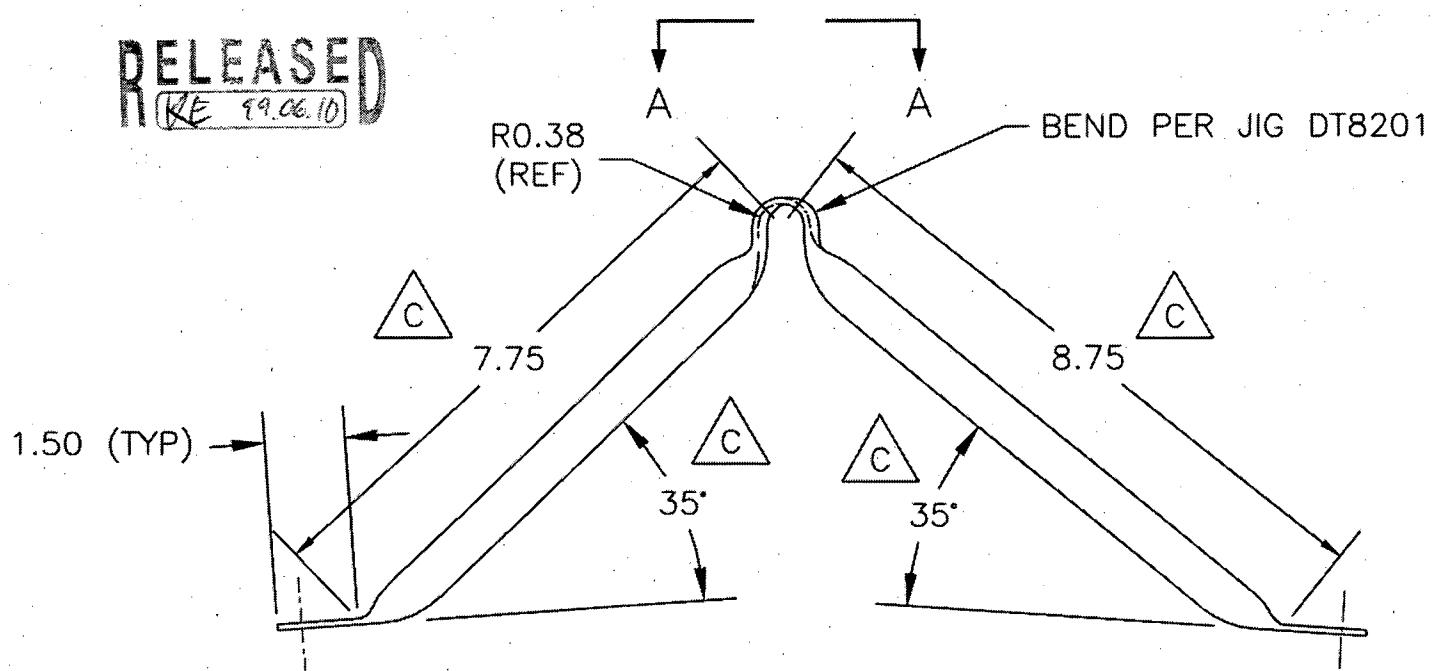
CUT LENGTH: 23.25 INCHES

VIEW A-A

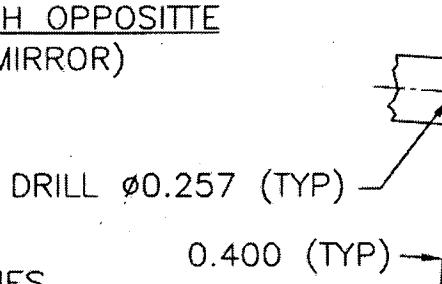
MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41316AO

RELEASED
RE 99.06.10



D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)



0.400 (TYP)

CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DESIGN JB	DRAWN BY <i>R.E.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>R.E.</i>	DRAWING NO. D2013
DATE 99.06.07	TITLE MIRROR BRACKET	SHEET 3 OF 3 SCALE NRS

DART

COPY ISSUED
DO